

Work Order ID 67949

Tuesday, April 05, 2011 7:44:36 AM



Page 1

Item ID: D3186-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Door, RH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/04/05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3186	Rev E								

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Trim door to fit spacepod before drill holes and cut out slots for latch as per
dwg D3186 (D3186-4 detail)

AT 11-06-21

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Subsels

(X)

120

0.00



Identify as per dwg & Stock Location: comp. for

Packaging

Memo

0.00

Packaging

AT 11-06-21

Work Order ID 67949

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Page 2

Item ID: D3186-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Door, RH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/22

MF
11-06-22

Picklist Print

Tuesday, April 05, 2011 7:44:33 AM

Page 1

Work Order ID: 67949



Parent Item: D3186-4



Parent Item Name: Spacepod Door, RH



Start Date: 4/5/2011

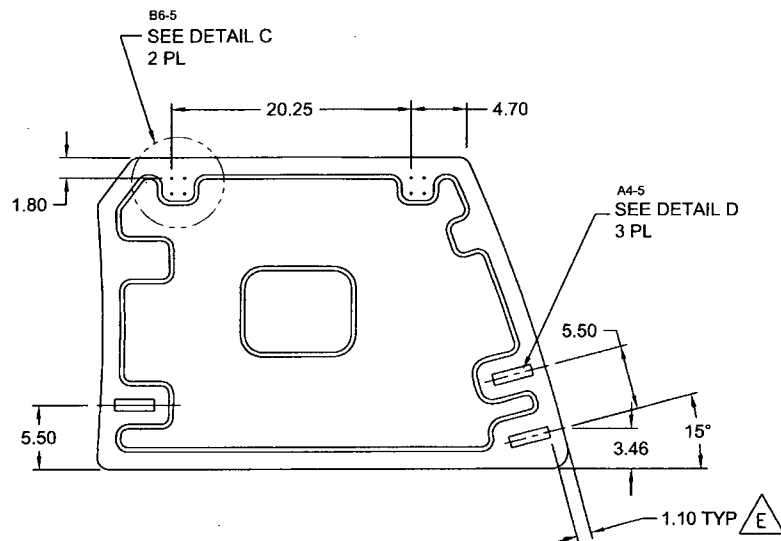
Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-11 EC
IPP rev.B revD 07.03.07 ec IPP Rev:C
10-08-11 added trim door before drilling DD verf:EC

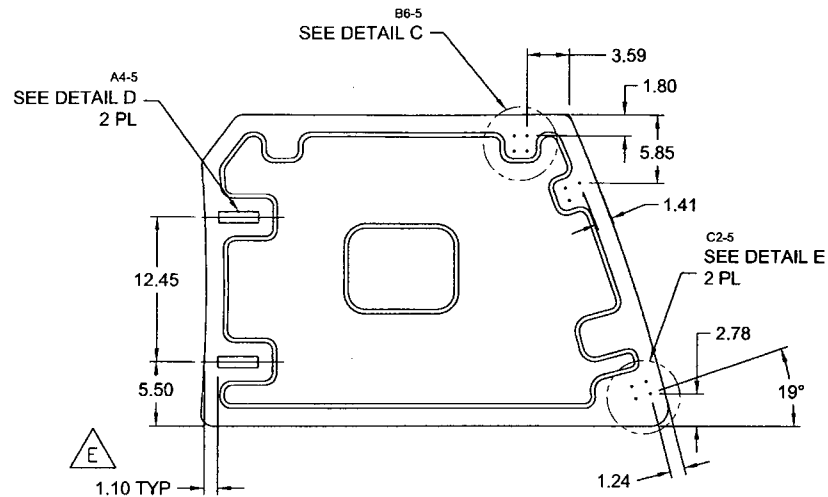
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2M  SPACEPOD DOOR RH		Manufactured	No			100	Each	1.0000	1	1			
<div>367951</div> <div> 11-06-21</div>													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				CA				1					
				66594				1					



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

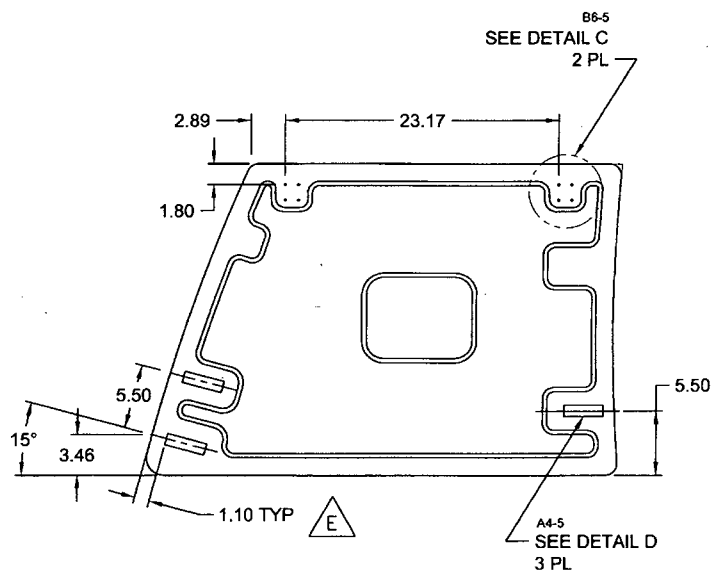


D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

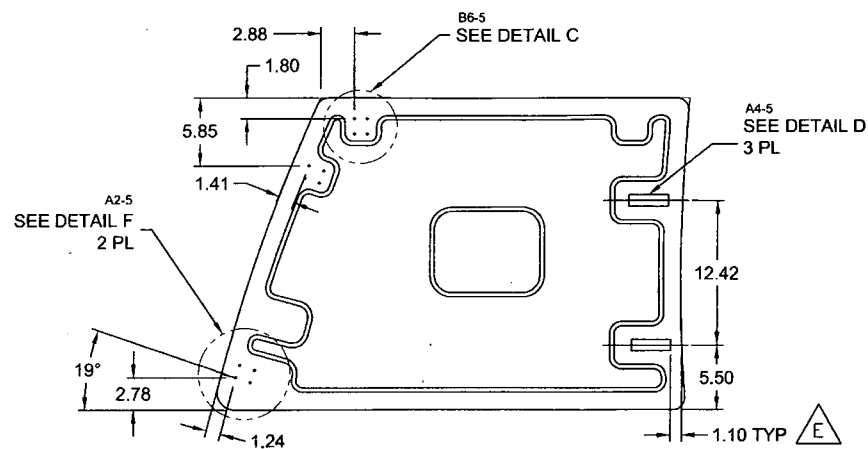
RELEASED
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026		RF	09.07.08
D	UPDATE DIMENSIONS		LE	07.02.22
C	REMOVED D0600-XXX LABELS		LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/4 ADDED		LE	06.09.25
A	NEW ISSUE		CP	03.03.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	IP	DRAWING NO.	REV. E	
MFG. APPR.		D3186	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		SPACEPOD DOOR	NTS	
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C21104105
W10:67949



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M







D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

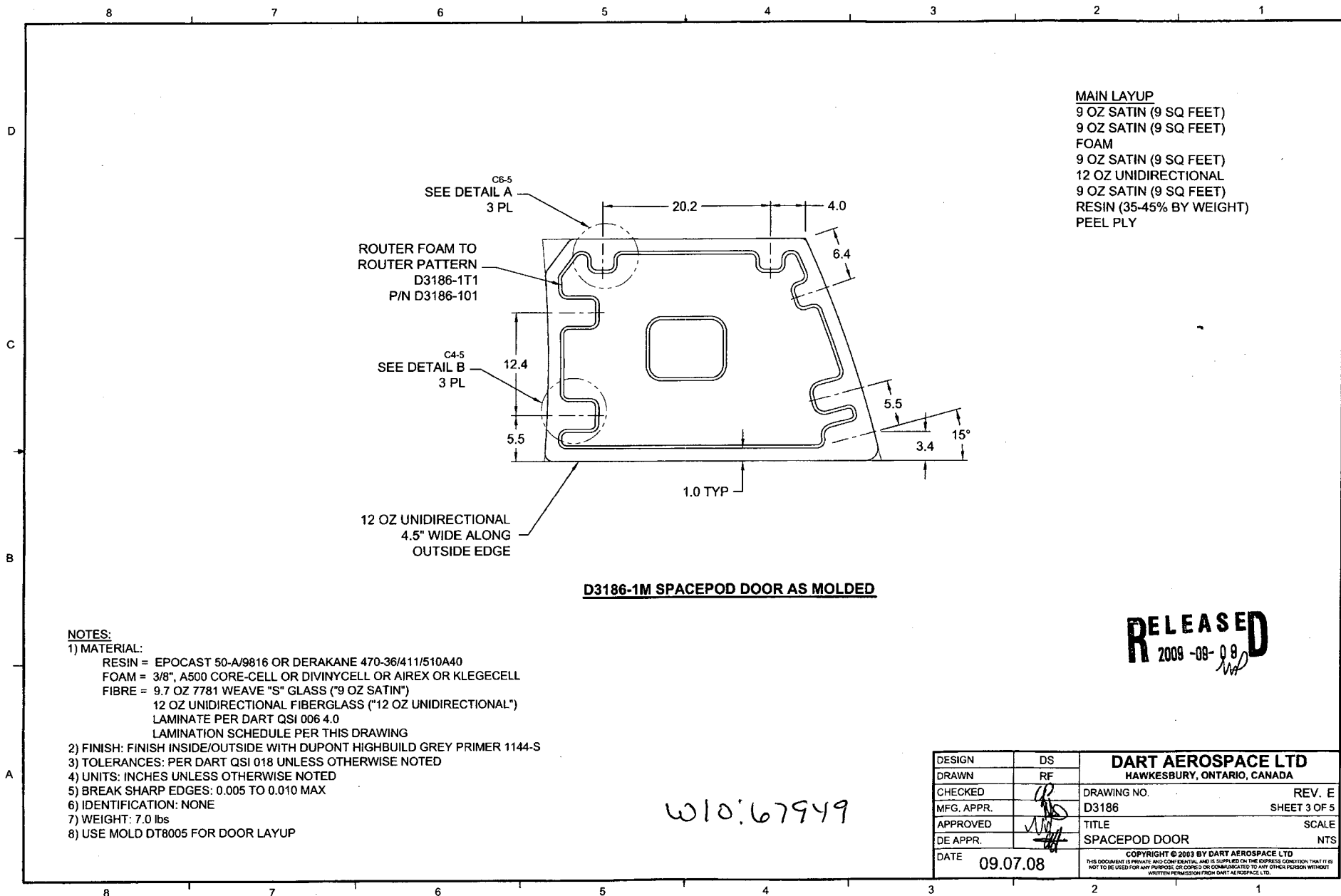
RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

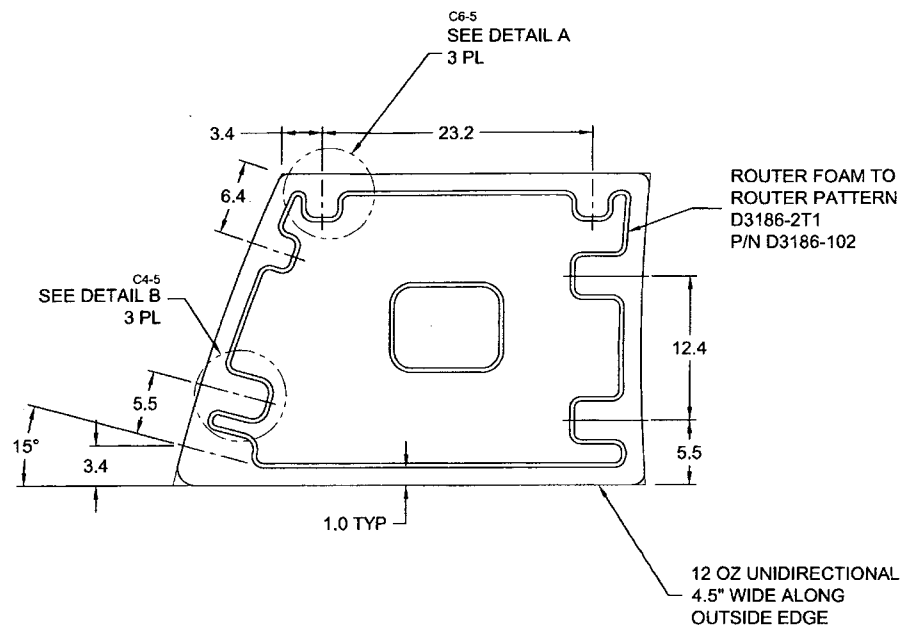
8) USE MOLD DT8005 FOR DOOR LAYUP

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2008-08-08

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MFG. APPR.	MS	D3186	SHEET 3 OF 5
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9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



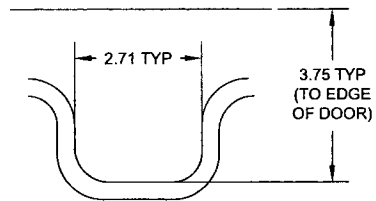
1) MATERIAL:

- RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 7.0 lbs
8) USE MOLD DT8006 FOR DOOR LAYOUT

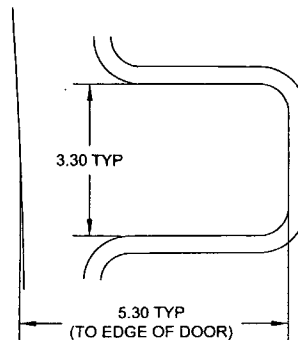
D3186-2M SPACEPOD DOOR AS MOLDED

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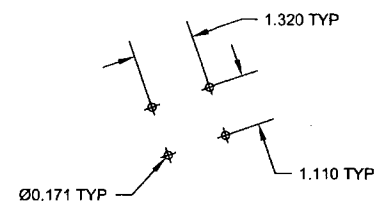
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DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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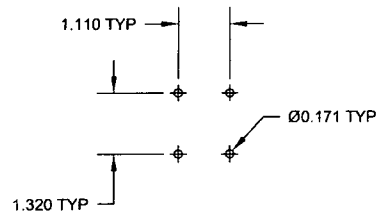
DETAIL A
SCALE 4X
D6-3
D4-4



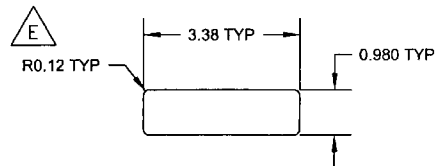
DETAIL B
SCALE 4X
C6-3
C6-4



DETAIL E
SCALE 4X
C1-1

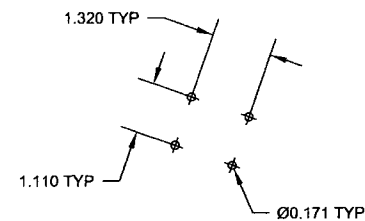


DETAIL C
SCALE 4X
D7-1
D3-1
D6-2
D3-2






NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D
SCALE 4X
C5-1
D4-1
B6-2
C2-2



DETAIL F
SCALE 4X
C4-2

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